

GERMAN RELIABILITY WITH GLOBAL FLEXIBILITY ▶▶▶

CONSTANTA



TEEPACK
wrap your brand in quality

GERMAN RELIABILITY...

In 1948, the late Mr. Rambold invented the first double-chamber tea bag. However, as a man who was always thinking ahead, he also developed the machine to produce it. He took his time, meticulously going over every part and improving them restlessly.

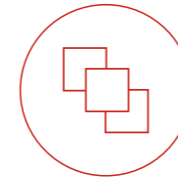
The result was a machine that revolutionized the market when introduced in 1949 – a machine that is still working reliably in factories around the world and is still considered the benchmark for those who love good tea in proper tea bags.

We not only honor our founder in keeping his philosophy alive, but also by keeping his spirit alive: always on the cutting edge of development and setting new standards.
Let us honour him together!

...WITH GLOBAL FLEXIBILITY

BUILT ON
TRADITION
MADE FOR
TOMORROW ▶▶▶
CONSTANTA

BENEFITS OF **CONSTANTA**



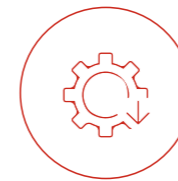
MODULARITY

- ✓ Wide array of consumables
- ✓ Plug-and-play approach
- ✓ Easily expandable in the field
- ✓ Integrated tag punching station



RELIABILITY

- ✓ Low energy consumption
- ✓ High ratio of good tea bags
- ✓ Easy maintenance
- ✓ Automatic faulty bag ejection



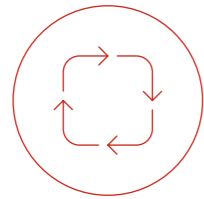
LOW OPERATING COSTS

- ✓ Mechanically focused
- ✓ Improved materials flow
- ✓ Ergonomic design
- ✓ Knotted bags only



HYGIENIC DESIGN

- ✓ Enclosed working chamber
- ✓ Only needed parts in working chamber
- ✓ Optional dust extraction system



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PRODUCT FLOW

1. DOSING

Tea is placed onto the filter paper

2. BAG FORMING

Bag is formed from filter paper

3. BAG HEAD KNOTTING

Thread is knotted to the bag

4. BAG REVERSING

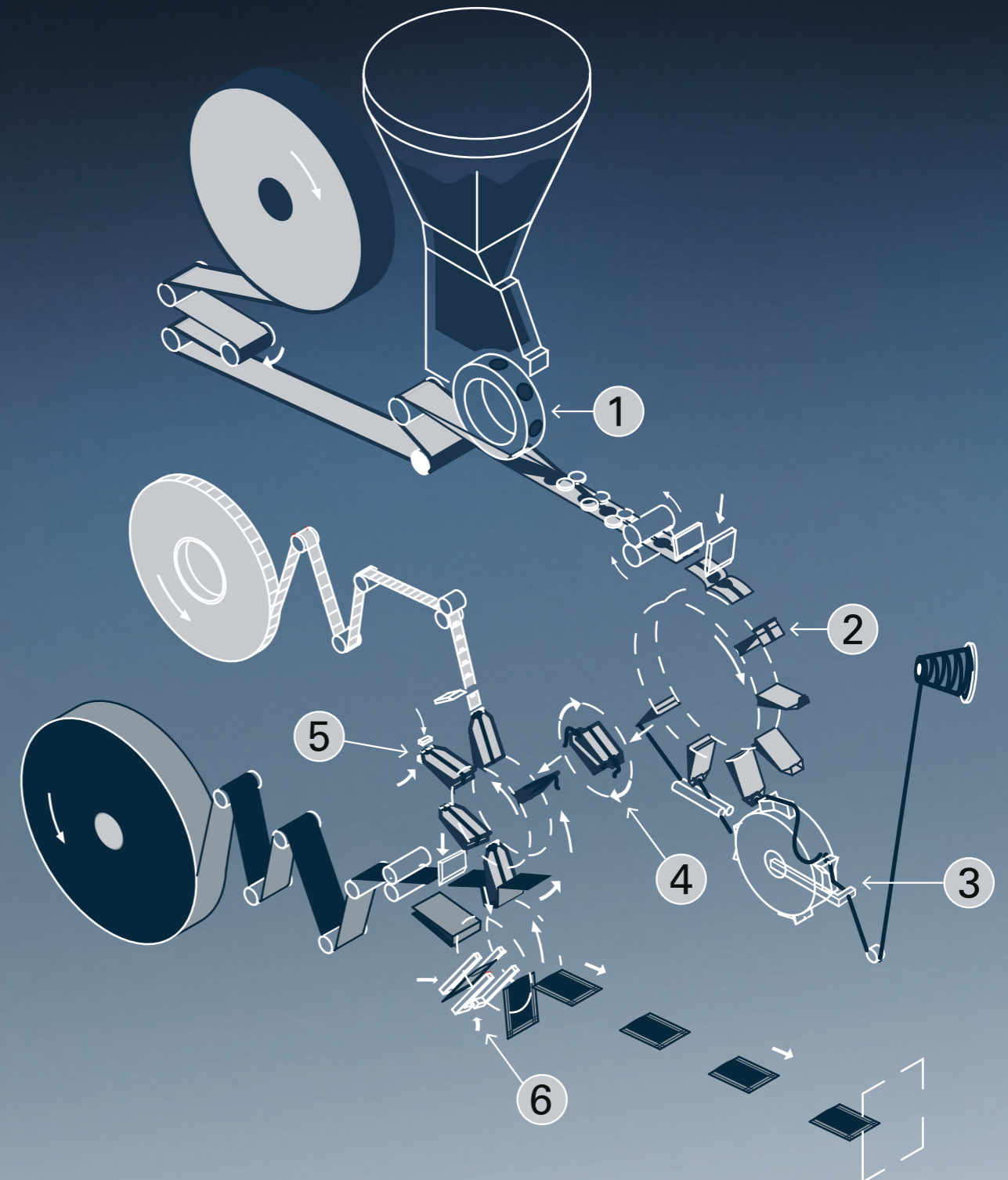
Thread is wrapped around the bag

5. TAG KNOTTING

Tag is placed & knotted to the thread

6. ENVELOPING

Bag is sealed into an envelope





STANDARD EQUIPMENT

CONSTANTA

TECHNICAL DATA WITH PRE-GROUPING

Production speed:
up to 250 bags/minute

Length x width:
approx. 2910 x 1178 mm

Height with hopper:
approx. 2274 mm

Height without hopper:
approx. 2080 mm

Net weight: approx. 2315 kg*
*depending on configuration

Electric power connection: 20 kW

Average power consumption:
up to 5 kWh
(including the consumption of the connected dust extractor)

Max. power consumption: 8 kWh

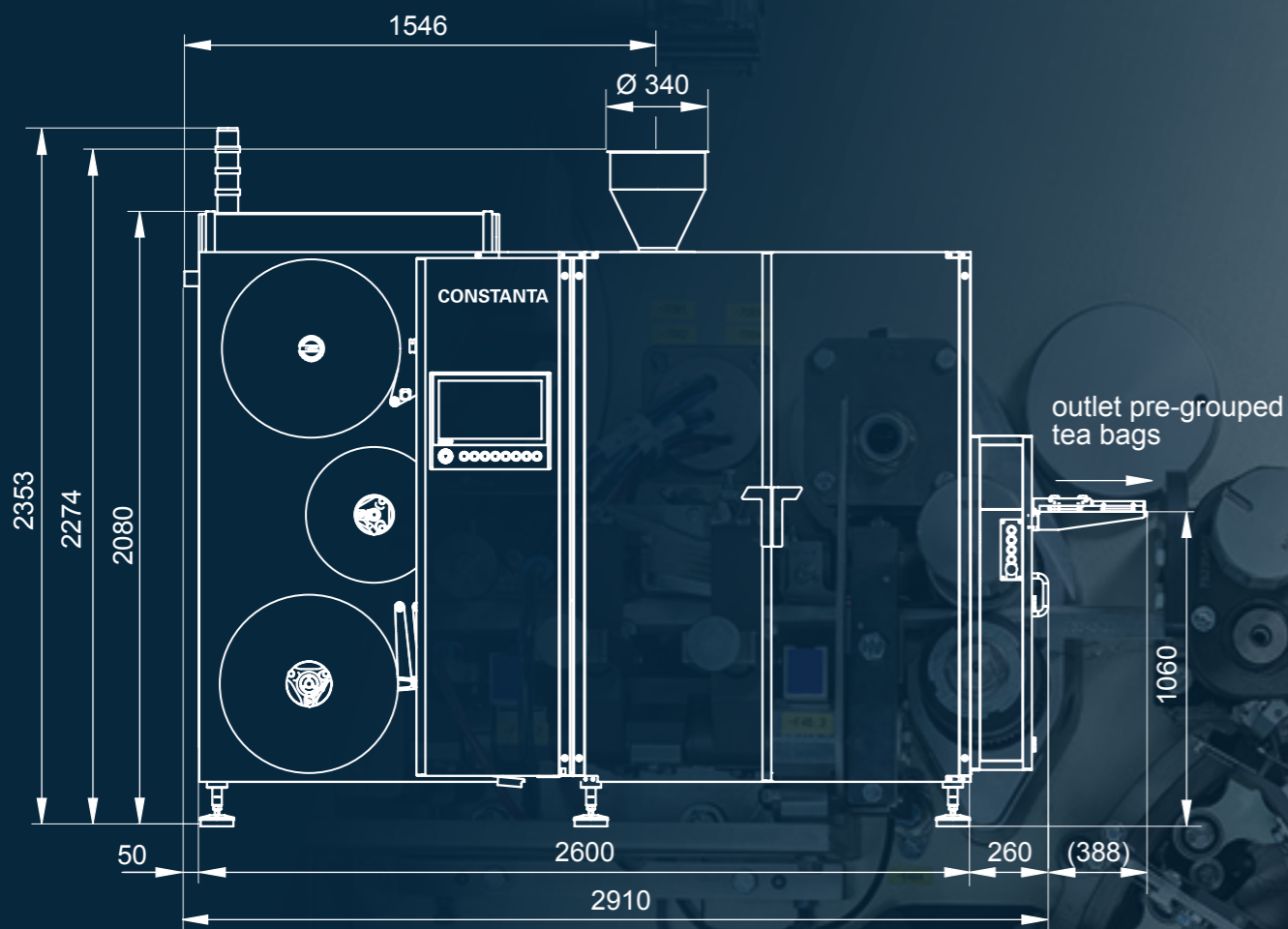
Operating pressure: 6 bar

Compressed air consumption:
up to max. 210 NI/min.

Compressed air connection: 1/2"

Note: The power consumption and compressed air consumption depend on the machine configuration.

The dust extractor is installed directly to the machine. It does not need a separate power supply.



TEA BAGS



Filter bag with tag



Filter bag with tag in crimped envelope paper



Filter bag with tag in heat-seal envelope

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CUSTOMIZED EQUIPMENT

END-OF-LINE MODULE (ELC)

ELC - OPTIONS

- With box erector and lid closer for folding boxes (pre-glued boxes)
- 1 row (naked bags), 1 row (paper envelope bags + heat-seal envelope bags or cold-seal envelope bags)
- Short flap (Kurzlasche) gluing and short flap closure directly in the END-OF-LINE MODULE (ELC) *
- Embossing system for embossing on the lid
- Embossing system for embossing on the short flap (Kurzlasche) of the lid

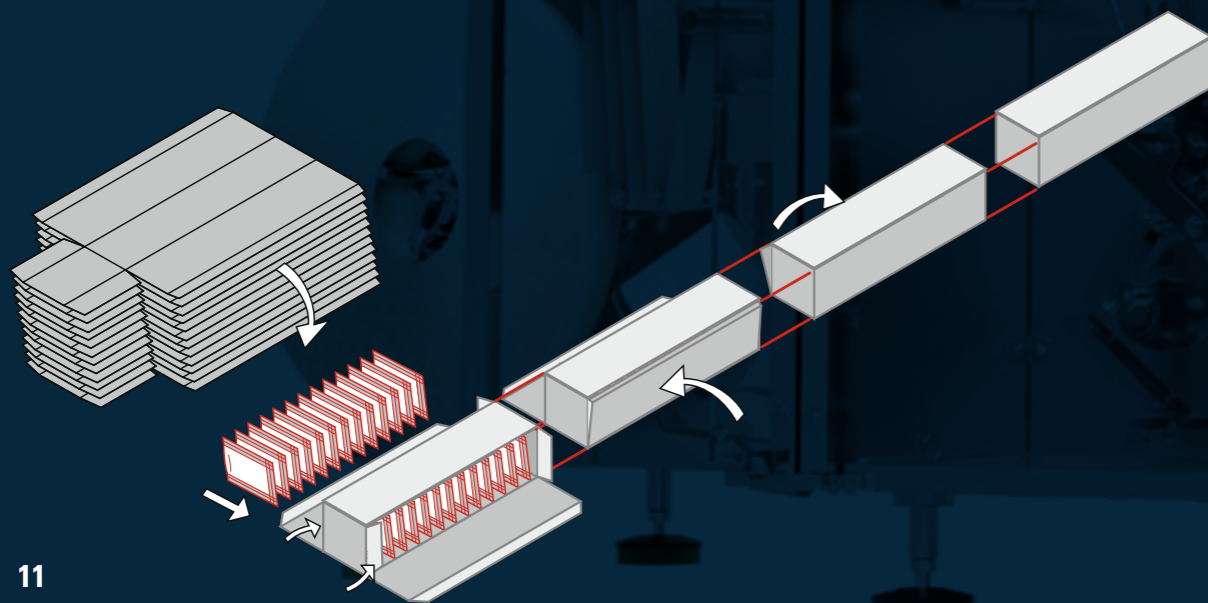
BOX ERECTING DEVICE

- Erects folding boxes (pre-glued boxes)
- Output: up to 15 boxes/min.

LID CLOSING DEVICE

- Closes the lid and the bottom of the filled boxes
- Output: up to 15 boxes/min.

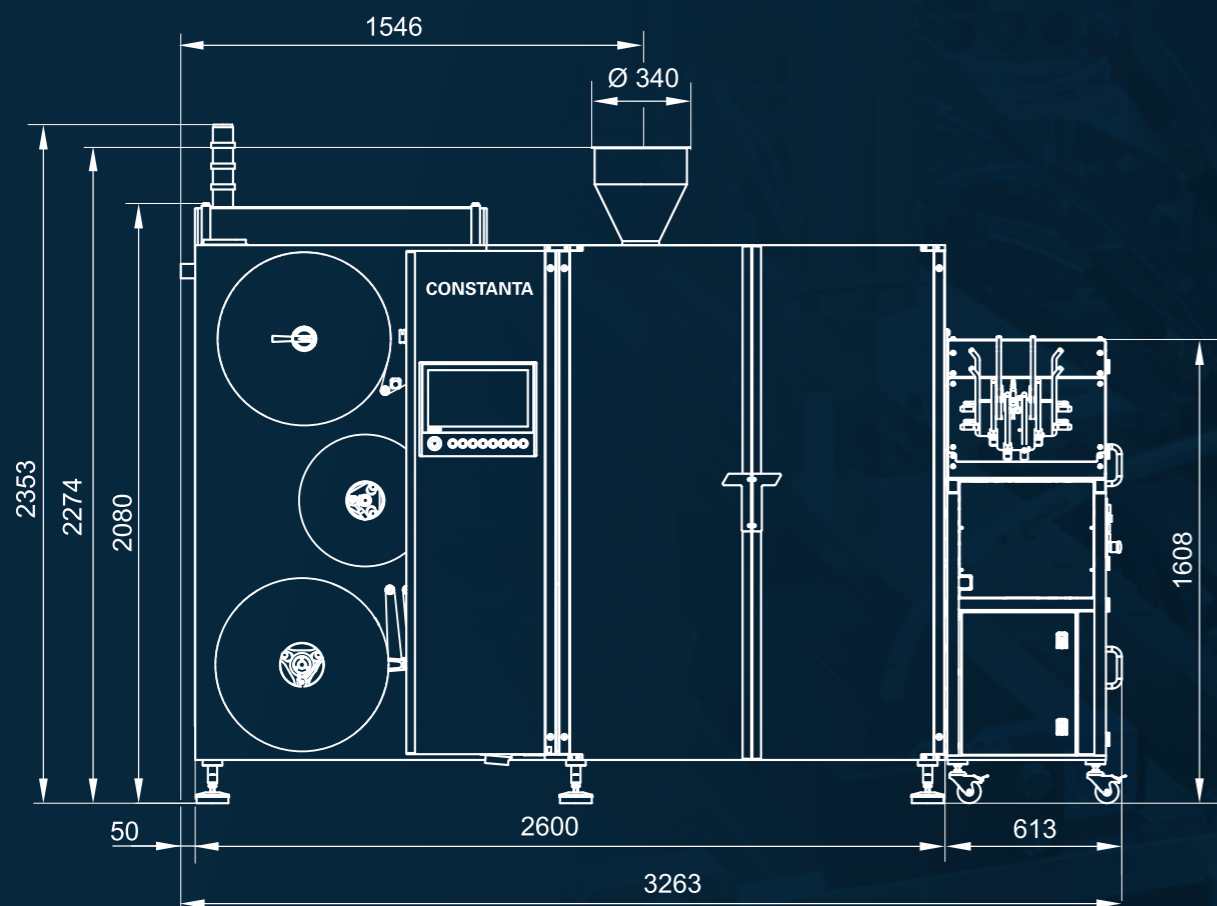
*The short flap (Kurzlasche) is glued and closed (double closing lids-top and bottom) in the END-OF-LINE MODULE (ELC). No further machinery is required.





CUSTOMIZED EQUIPMENT

END-OF-LINE MODULE (ELC) FOR CONSTANTA



TECHNICAL DATA WITH END-OF-LINE MODULE (ELC)

Production speed:
up to 250 bags/minute¹

Length x width:
approx. 3263 x 1275 mm

Height with hopper:
approx. 2274 mm

Height without hopper:
approx. 2080 mm

Net weight: ca. 2315 kg
+ approx. 240 kg (ELC):
2555 kg²

Electric power connection:
20 kW

Average power consumption:
up to 5 kWh (including
the consumption of the
connected dust extractor) +
approx. 0.8 kWh (ELC with
gluing unit) = approx. up to
5.8 kWh

Max. power consumption: 9 kW

Operating pressure: 6 bar

Compressed air consumption:
up to max. 340 NI/min.

Compressed air connection: 1/2"

Capacity:
10 bags/box
(fewer than 10 bags/
box on request)

Box dimensions:
Width: 42–70 mm
Height: 60–80 mm
Length: 80–180 mm

Box filling speed:
up to 15 boxes/minute

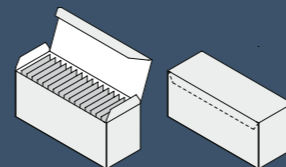
¹ The speed depends on the count
used on the END-OF-LINE
MODULE (ELC).

² Depending on configuration

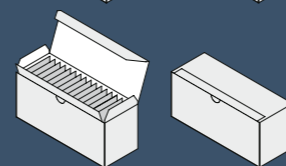
Note: The power consumption and compressed air consumption depend on the machine configuration.
The dust extractor is installed directly to the machine. It does not need a separate power supply

POSSIBLE BOX TYPES

- Standard tuck-in closure box and Kurzlaschen closure box
- Single-row folding boxes (pre-glued boxes) can be processed



The **TUCK-IN CLOSURE BOX** is a standard box used by most tea manufacturers worldwide.



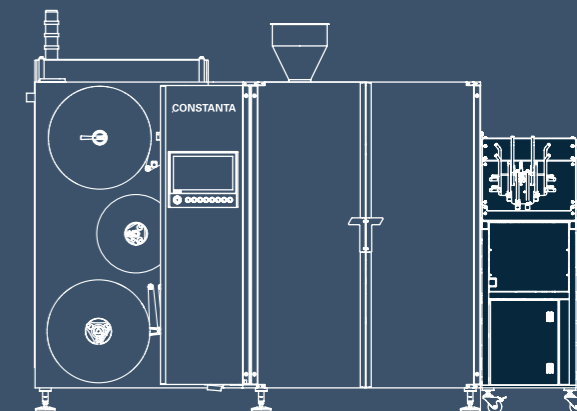
The **KURZLASCHEN CLOSURE BOX** offers more security by two glued short flaps (Kurzlasche) as well as a re-closable solution and does not need overwrapping.

*The short flap (Kurzlasche) is glued and closed (double closing lids-top and bottom) in the END-OF-LINE MODULE (ELC).
No further machinery is required.

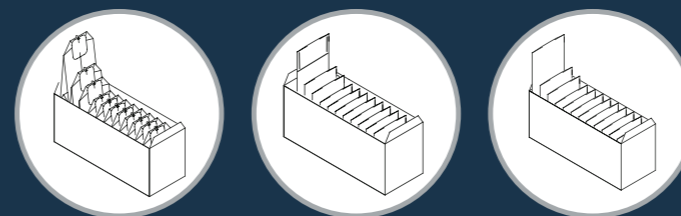
CONSTANTA MODULES

MAIN MODULE

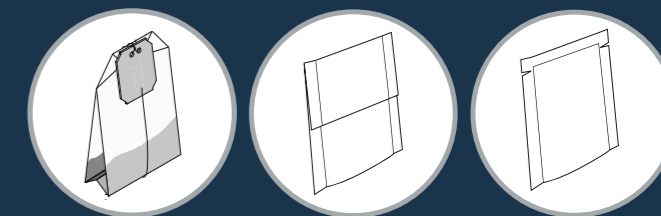
EOL MODULE (ELC)



PACKAGING



TEA BAGS

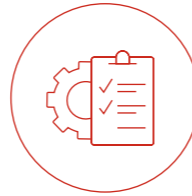


Filter bag
with tag

Filter bag with
tag in crimped
envelope paper

Filter bag with
tag in heat-seal
envelope

CONSUMABLES



BAGS

	TEA BAG SIZES			
	Size	W (mm)	H ¹ (mm)	max. bag volume (cm ³)
	02	40	60	up to 9.0
	03	44	60	up to 10.5

ENVELOPES

	ENVELOPE SIZES – CRIMPED PAPER Filter bag with tag in crimped envelope paper					ENVELOPE SIZES – HEAT-SEAL Filter bag with tag in heat-seal envelope			
	Size	W (mm)	H (mm)	max. bag volume (cm ³)		Size	W (mm)	H (mm)	max. bag volume (cm ³)
	02 (40x60)	56	67	up to 9.0		02 (40x60)	66	77	up to 7.0
	02 (40x60)	55	67	up to 9.0		02 (40x60)	63	72	up to 7.0
	03 (44x60)	60	67	up to 10.5		03 (44x60)	66	77	up to 9.5
	03 (44x60)	63	72	up to 10.5		03 (44x60)	63	72	up to 9.5

REELS

	FILTER PAPER REEL SIZES					
	Size	Dm (mm)	d+2 (mm)	L (mm)	W+0.5 (mm)	g/m ²
	02 (40x60)	600	75	154	94	12
	03 (44x60)	600	75	154	103	12

	ENVELOPE PAPER REEL SIZES						
	Size	Bag type	Dmax (mm)	d+1 (mm)	L1+/-0.5 (mm)	W+/-0.2 (mm)	g/m ²
	02 (40x60)	56x67	600	75 oder 152	144.5 (145)	56	60-70
	02 (40x60)	55x67	600	75 oder 152	145	55	60-70
	03 (44x60)	60x67	600	75 oder 152	144.5 (145)	60	60-70
	03 (44x60)	63x72	600	75 oder 152	157.5	63	60-70

ENVELOPE FOIL REEL SIZES

Size	Bag type	max. bag volume (cm ³)	Dmax (mm)	d+1 (mm)	L1+/-0.5 (mm)	W+/-0.2 (mm)
02 (40x60)	66x77	up to 7.0	600	75 or 152	154	66
02 (40x60)	63x72	up to 7.0	600	75 or 152	144	63
03 (44x60)	66x77	up to 9.5	600	75 or 152	154	66
03 (44x60)	63x72	up to 9.5	600	75 or 152	144	63

CARDBOARD TAG SIZES (STANDARD SIZE "Z")

Size	W (mm)	L (mm)	d (mm)	Dmax (mm)
Z	28	32	120 or 152	500
M	28	28	120 or 152	500
X	26	28	120 or 152	500
T	25.4	31.75	120 or 152	500
O	23	28	120 or 152	500
Y	20	24	120 or 152	500

THREAD SPOOL SIZES

Size	Dmax	+/-0.3	Hmax
02	180	47	180
03	180	47	180

END-OF-LINE MODULE (ELC) FOR 1 ROW OF BAGS OR OUTER ENVELOPES

1 ROW	BOX SPECIFICATIONS FOR FOLDING BOXES (PRE-GLUED BOXES) *	
	TUCK-IN BOX	KURZLASCHEN SHORT FLAP CLOSURE BOX*
	Weight: 280 – 320 g/m ² Thickness: 0.40 – 0.45 mm Number of bags or envelopes: 1 row, 10 – 30 bags/box (Fewer than 10 bags/box on request)	Box dimensions: Width: 42 – 70 mm Height: 60 – 80 mm Length: 80 – 180 mm
*The short flap (Kurzasche) is glued and closed (double closing lids-top and bottom) in the END-OF-LINE MODULE (ELC). No further machinery is required.		

⌘ INSTALLED SOLUTIONS

Our service packages for your TEEPACK system.

Maximum machine performance.
Minimum effort.



And expandable at any time.

Get professional support, predictable maintenance and access to the latest updates – customized to your needs.



THE BEST FOR YOUR MACHINE DIRECTLY FROM TEEPACK

More predictability. Less downtime. More performance.

Original spare parts for original 100% performance.

3 PACKAGES FULL CONTROL

BASIC

- ✓ 10 hours of remote support
- ✓ Express request handling

OCCASIONAL SUPPORT
& QUICK HELP

PREMIUM

- ✓ 50 hours of remote support
- ✓ Express request handling
- ✓ 2 x 2 weeks of maintenance/training
- ✓ 5% service discount
- ✓ 5% spare part discount

FULL SERVICE &
MAXIMUM PERFORMANCE

PLUS

- ✓ 20 hours of remote support
- ✓ Express request handling
- ✓ 1 x 2 weeks of maintenance/training
- ✓ 3% service discount
- ✓ 3% spare part discount

REGULAR SUPPORT
WITH SAVINGS

EVERY FUNCTION COUNTS EVERY MODULE WORKS

Our services at a glance.



REMOTE SUPPORT

- Priority Support
- Remote Access



INSPECTION

- System Check
- Function Analysis



TRAINING

- Safe Operations
- Effective Maintenance



MAIN- TENANCE

- Professional Repairs
- Preventive Service



COMMIS- SIONING

- Machine Ramp-Up
- Production Monitoring



CONSULTING

- Plant Analysis
- Performance Improvement



Our service is available internationally. This is quality “Made in Germany” – worldwide: in Australia, Bangladesh, China, India, Indonesia, Iran, Italy, Japan, Kazakhstan, Kenya, Nepal, Portugal, Russia, South Africa, South Korea, Spain, Sri Lanka, Taiwan, Turkey and Ukraine. And, of course, Germany.

You can find the contact details of our representatives on our website.

Get in touch
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